

Work Order ID 70213

Tuesday, May 31, 2011 11:40:00 AM



OK to IIN-D206-628-Rev G
~~PRELIMINARY ISSUE~~ Page 1
CP 11.6.06

Item ID: D206-628-026BL

Accept



Setup Start



Revision ID: PRELIM

Item Name: Crew Step, RH, Blue

Stop



Start Date: 5/31/2011 Start Qty: 2.00



Cust Item ID:



Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-05-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4308

A

IIN-D206-628

PGT G H

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-628-026
CHG 001

0.00

*Subtotal
to Rev G 722*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/7 sf 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70213

Tuesday, May 31, 2011 11:40:00 AM



Page 2

Item ID: D206-628-026BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC4- 100% Inspect kits for completeness

0.00

8/11/06/02



QC

Memo

0.00

10 Rev 67770

Quality Control

(x2)

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Package per PPP D206-628-026

Packaging

11/6/08

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/08

11-06-08

POSITIVE RECALL

EFFECTIVE *11/05/04*

AUTH *[Signature]*

RELEASED *11.06.06* DATE *[Signature]*

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 31, 2011 11:40:07 AM

Page 1

Work Order ID: 70213

Parent Item: D206-628-026BL

Parent Item Name: Crew Step, RH, Blue



Start Date: 5/31/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 11.05.26 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
Sn D4308-042 		Manufactured	No				Each	0.0000	x1 	2 B7012, S			
Step, RH Crew													
Sn D2731-7RG 		Manufactured	No				Each	0.0000	x2 	4 B701185P			
Mounting Lug													
Sn D3394-3RG 		Manufactured	No				Each	0.0000	x2 	4 B70119S			
Lug													
Sn D4309-1 		Manufactured	No				Each	-20.0000	x2 	4 S			
Bushing													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					139e			20					
					70099			20					
Sn AN4-11A 		Purchased	No				Each	298.0000	x4 	4 8 11/6/7 S			(2)
Bolt													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST356			100					
					117872			100					
					ST357			198					
					110382			1					
					115316			197		8			

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 31, 2011 11:40:07 AM

Page 2

Work Order ID: 70213

Parent Item: D206-628-026BL

Parent Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-12A

Purchased

No

Each

213.0000



Bolt



x4

8

Location

Loc Qty

Loc Code

ST357

213

115422

113

117508

100

AN4-15A

Purchased

No

Each

391.0000



Bolt



x2

4

Location

Loc Qty

Loc Code

ST308

6

116786

6

ST357

200

117423

200

ST358

185

117794

34

117854

51

117872

100

MS21042-4

Purchased

No

Each

252.0000



USE MS21042L4



x1

12

M116823 11/6/7 SD (2)

Location

Loc Qty

Loc Code

ST299

252

100743

9

5389

78

5461

3

6844

19

7690

24

8182

115

9229

4

Tuesday, May 31, 2011 11:40:07 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 31, 2011 11:40:07 AM

Work Order ID: 70213

Parent Item: D206-628-026BL

Parent Item Name: Crew Step, RH, Blue



Start Date: 5/31/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

Each

3,635.000



Washer

Handwritten notes: 46, 11/6/12, 12, 51, (2)

Location

Loc Qty

Loc Code

FP-B

8

116805

8

ST298

3627

116025

26

116805

0

117291

1001

~~117460~~

1600

117591

1000

Handwritten notes: 12, 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

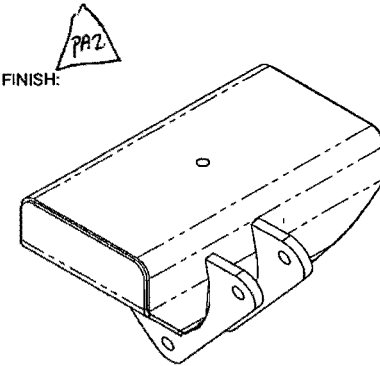
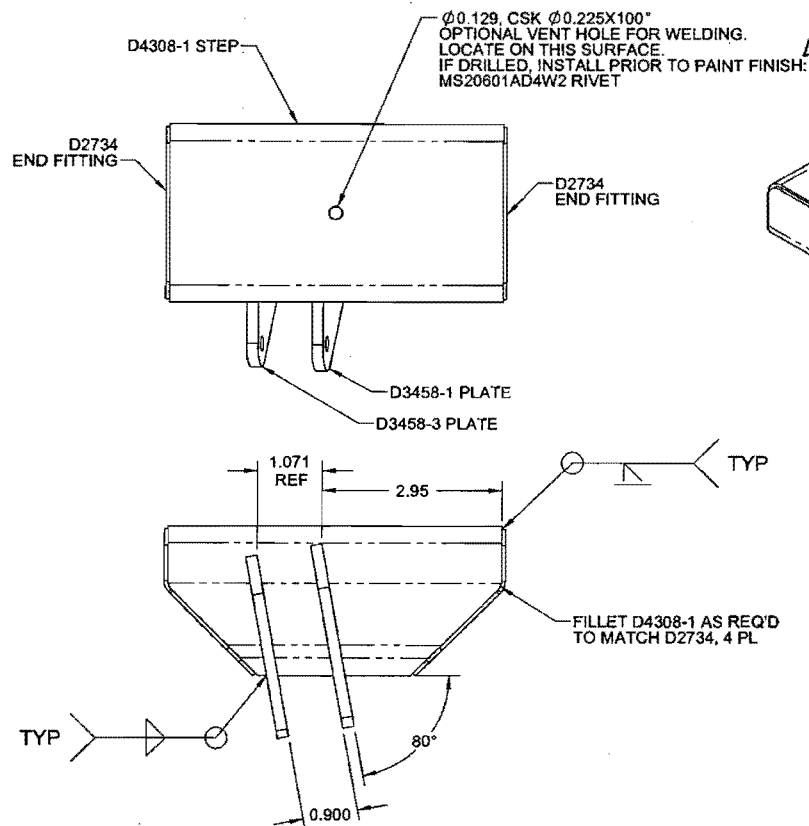
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70113

AS11-05-24

PRELIMINARY ISSUE

Rev. PAZ 11.01.13

D4308-041 STEP, LH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4308-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

PAZ	ADD WING-WALK, VENT HOLE	11.01.13
REV.	NEW ISSUE	OP
DESIGN		DATE
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.12.17	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4308**

TITLE **STEP, CREW**

SCALE **NTS**

REV. **PAZ**

SHEET 1 OF 3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

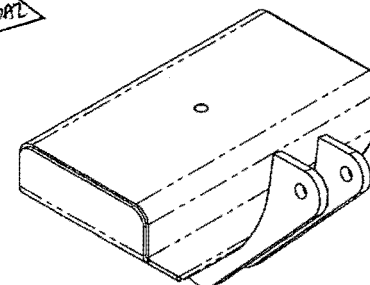
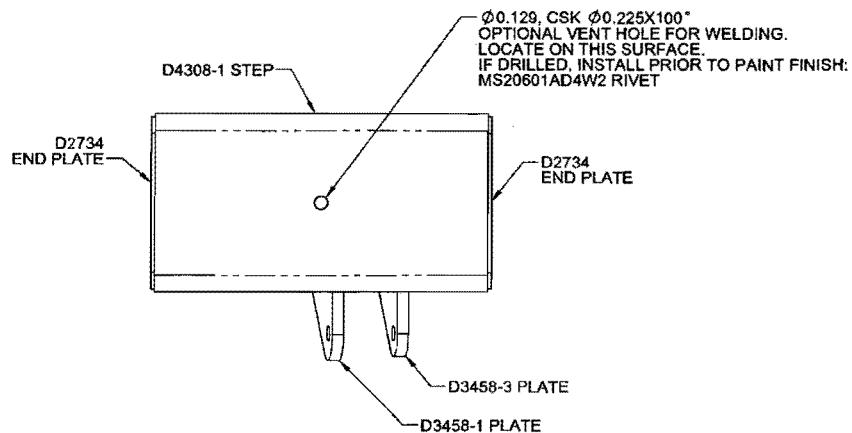
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

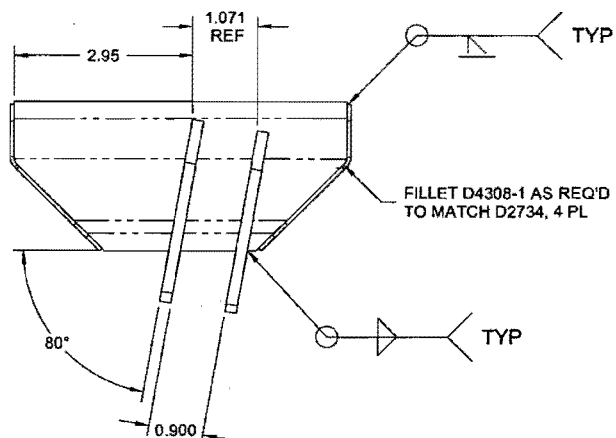
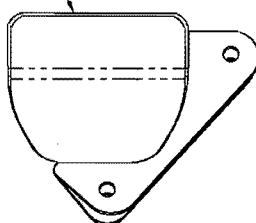
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



APPLY BLACK
ANTI-SKID ON TOP
SURFACE TO BOTTOM
OF TOP RADIUS



D4308-042 STEP, RH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4308-042" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

PRELIMINARY ISSUE

Ra PAZ 11.11.13

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
DATE	10.12.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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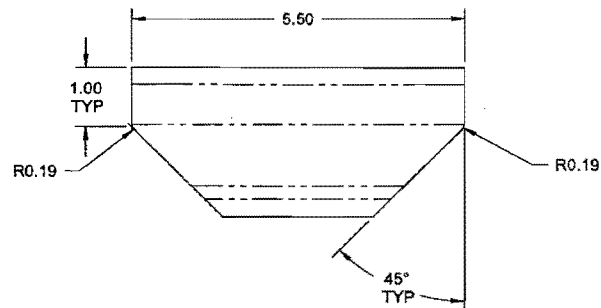
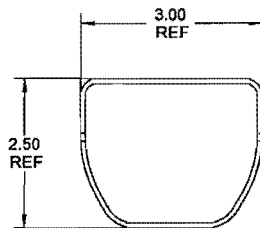
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4308-1 STEP

W/O ~~70107~~
70213

PRELIMINARY ISSUE

REV PAZ CP 11.01.13

- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
DATE	10.12.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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5.4 CREW STEP PARTS LIST

Qty -015	Qty -016	Qty -025	Qty -026	Qty -035	Qty -036	Part Number	Description
X						D206-628-015	CREW STEP, LH 206A/B
	X					D206-628-016	CREW STEP, RH 206A/B
		X				D206-628-025	CREW STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-026	CREW STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-035	CREW STEP, LH 407
					X	D206-628-036	CREW STEP, RH 407
				2	2	D2731-3RG	MOUNTING LUG
2	2	2	2			D2731-7RG	MOUNTING LUG
				2	2	D3394-1RG	MOUNTING LUG
2	2	2	2			D3394-3RG	MOUNTING LUG
		1		1		D4308-041	CREW STEP, LH
			1		1	D4308-042	CREW STEP, RH
2	2	2	2	2	2	D4309-1	BUSHING
1						D4357-041	CREW STEP, LH
	1					D4357-042	CREW STEP, RH
		4	4			AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

5.5 MAINTENANCE STEP PARTS LIST

Qty -017	Qty -018	Qty -027	Qty -028	Qty -037	Qty -038	Part Number	Description
X						D206-628-017	MAINTENANCE STEP, LH 206A/B
	X					D206-628-018	MAINTENANCE STEP, RH 206A/B
		X				D206-628-027	MAINTENANCE STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-028	MAINTENANCE STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-037	MAINTENANCE STEP, LH 407
					X	D206-628-038	MAINTENANCE STEP, RH 407
2	2			2	2	D2731-3RG	MOUNTING LUG
		2	2			D2731-7RG	MOUNTING LUG
2	2			2	2	D3394-1RG	MOUNTING LUG
		2	2			D3394-3RG	MOUNTING LUG
2	2	2	2	2	2	D4309-1	BUSHING
		1		1		D4342-041	MAINTENANCE STEP, LH
			1		1	D4342-042	MAINTENANCE STEP, RH
1						D4358-041	MAINTENANCE STEP, LH
	1					D4358-042	MAINTENANCE STEP, RH
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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